



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200
Fax 613 632-5246

647.7913
Job Sheet 187046



Part No: 647.7913
Part Name: Doubler
Job Created: 11/27/18
Due Date: 12/14/18
Type: SOLD
Note: DWG REV N/C SHEET 5 IPP REV: A 12.10.03 NEW ISSUE DD VERF: JFS
Ship Via:

Part Weight: 0 lbs
Status: New
Job Tracking No:
Created By: Marie Lajeunesse
Description:
Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup	Run		
					Hrs	Hrs	Workcenter / Supplier	Lead Time
110	Waterjet - Flow - 1	8 pcs	12/14/18	0.00 0.48			Waterjet - Flow	
120	QC	8 pcs	12/14/18	0.00 0.00			QC2 Waterjet-1	
130	QC	8 pcs	12/14/18	0.00 0.00			QC8-1	
140	Outsource	8 pcs	12/14/18				ATG001-VC	5
150	Packaging	8 pcs	12/14/18	0.00 0.00			Packaging2	
160	QC	8 pcs	12/14/18	0.00 0.00			QC5	
170	Spray Paint	8 pcs	12/14/18	0.00 0.18			Spray Paint	
180	QC	8 pcs	12/14/18	0.00 0.00			QC14	
190	Packaging	8 pcs	12/14/18	0.00 0.00			Packaging3-1	
200	QC21-SA	8 Ea	12/14/18	0.00 0.00			QC21	

Part Op 110 - 1-Cut as per Dwg
Descriptions: 140 - Issue P/O 041994
170 - PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)
190 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
ATG, black anodize and prime as per dwg 647.7913 Rev. A
21 JAN 02 2019

Job BOM

Part / Item
M2024T3S.063
Component Name
2024-T3 .063 Sheet
Quantity
.8000 sf (.1 ea)
Operation
110-Waterjet - Flow - 1
Container

Job Allocations

Operation
110-Waterjet - Flow - 1
Component Part
M2024T3S.063
Required
1
Inventory
95
Allocated
0

Part Specifications

Spec No
Description
Limits
Type
Special Comments

1 Doubler
0.100Inches + 0.005
0.105
Diameter
0.100

2 Doubler
0.313Inches + 0.006
0.319
Diameter
0.315

3 Doubler
0.313Inches ± 0.002
0.315
0.311

4 Doubler
1.313Inches ± 0.002
1.315
1.314

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Quality ☐ Other ☐																																								
Date : _____	Step #: _____	Container No: S134653 Part: 647.7913 Job No: 187046 Serial No/Batch: S134653 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 12/04/18																																								
Description Work Order I																																										
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;">Environment ☐</td> <td style="width:33%;">No Re-verification ☐</td> <td style="width:33%;">Pressure ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bend/r ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td></td> </tr> </table>		Environment ☐	No Re-verification ☐	Pressure ☐	Design ☐	Operator ☐	Bend/r ☐	Doc/Data ☐	Offset/Setup ☐	Centre ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Past Expiry Date ☐	Manufacturing Process ☐		Misidentified ☐	Past Due ☐		<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;"> Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%;"> Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:33%;"> Positioned Wrong outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>		Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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OTHER : _____																																										

			1.311	
5	Doubler	2.313Inches ± 0.002	2.315 2.311	2,314
6	Doubler	3.313Inches ± 0.002	3.315 3.311	3,312
7	Doubler	2.300Inches ± 0.002	2.302 2.298	2,301
8	Doubler	0.325Inches ± 0.002	0.327 0.323	0,325
9	Doubler	3.675Inches ± 0.002	3.677 3.673	3,674
10	Doubler	2.350Inches ± 0.002	2.352 2.348	2,351
11	Doubler	0.063Inches ± 0.010	0.073 0.053	0,063

Plex 11/27/18 8:49 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041994**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041994

PO Date: 12/10/18

Due Date: 12/21/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments: ** each line has different date**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186254	646.3311	RH Half - Upper Cutter Assembly Issue P/O to ATG :	Firmed	-	12/19/18	12 pcs	0 pcs	12 pcs	\$19.41/pcs	\$232.92
Line Item Note ASAP.:(											
2	184450	RBD29905-7	Bushing -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBD29905-7 Rev. 5	Firmed	-	12/17/18	30 pcs	0 pcs	30 pcs	\$4.03/pcs	\$120.90
3	185539	RBE105-13141W3-3	Plate -Issue P/O to ATG : ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT As Per Dwg RBE105-13141W3-3	Firmed	-	12/17/18	5 pcs	0 pcs	5 pcs	\$4.03/pcs	\$20.15

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PURCHASE ORDER **PO041994**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	186017	649.4816	Doubler Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF- 23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed	-	12/21/18	4 pcs	0 pcs	4 pcs	\$31.31/pcs	\$125.24
5	184103	RBH9928- 12-3	Tab Bender -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	12/14/18	12 pcs	0 pcs	12 pcs	\$4.03/pcs	\$48.36
6	187270	SWA3-300	Wire Clamp -Issue P/O to Groupe Atlech: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 3 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	12/18/18	43 pcs	0 pcs	43 pcs	\$3.21/pcs	\$138.03

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PURCHASE ORDER **PO041994**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	187046	647.7913	Doubler Issue P/O ATG, black anodize and prime as per dwg 647.7913 Rev. A	Firmed	-	12/17/18	8 pcs	0 pcs	8 pcs	\$4.03 61 9-89	\$32.24

Grand Total: \$717.84

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/17/18 3:34 PM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916872

Date: 19-Dec-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
4 ea	Part: 649.4816 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24334	Rev: E PO: PO041994 Line: 4	
8 ea	Part: 647.7913 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24337	Rev: A PO: PO041994 Line: 7	DAS 61 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>DEC 19 2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			